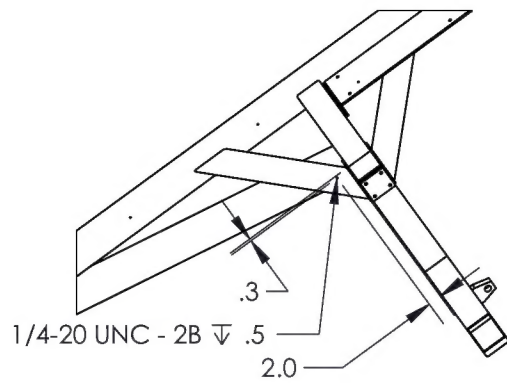
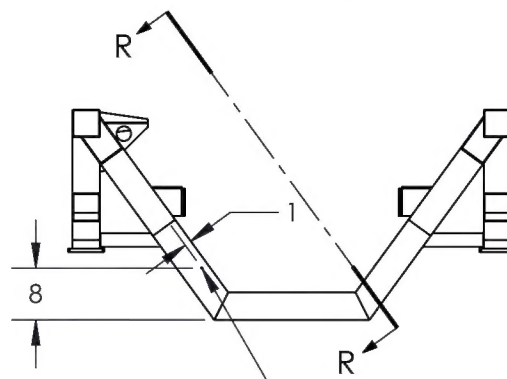


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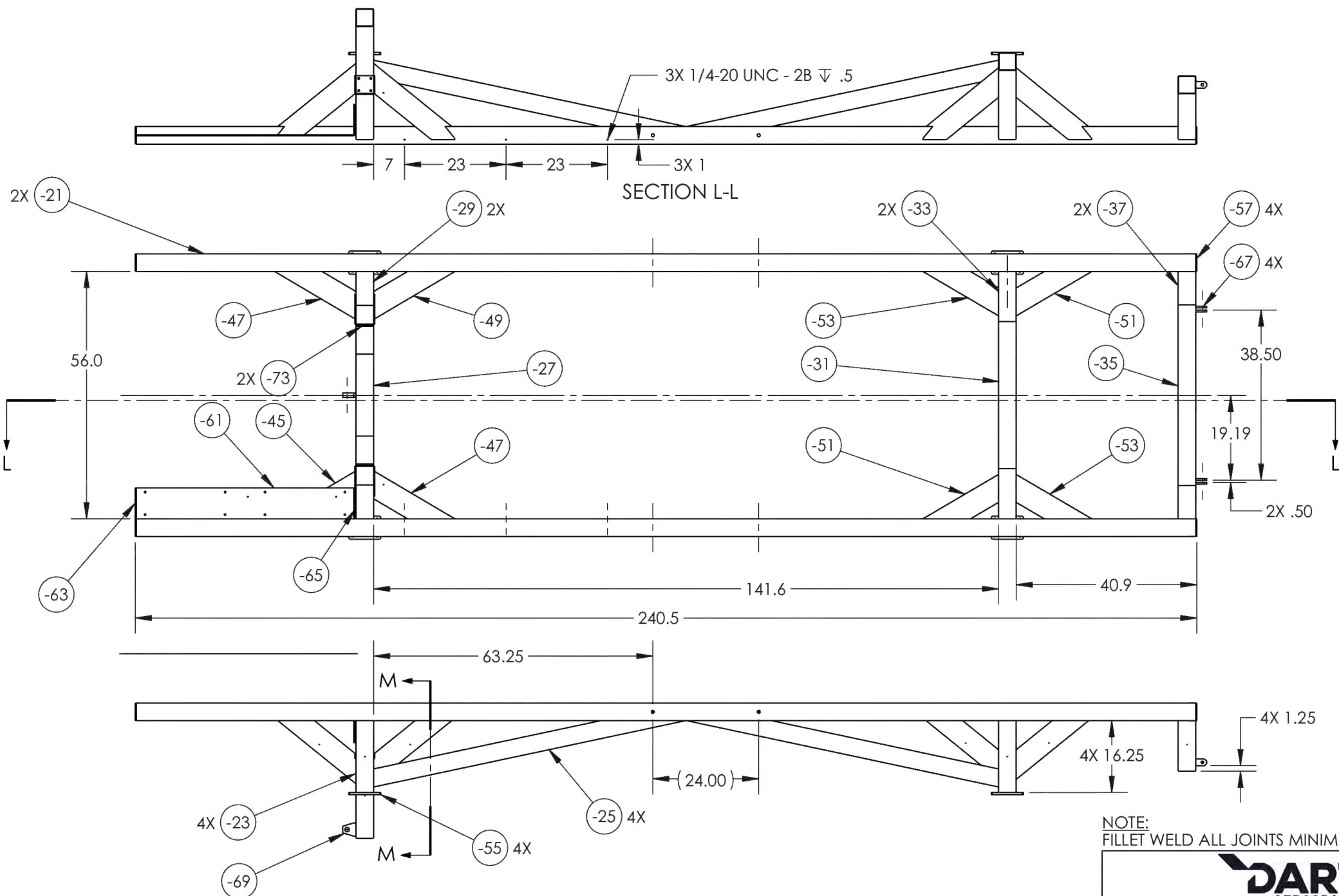
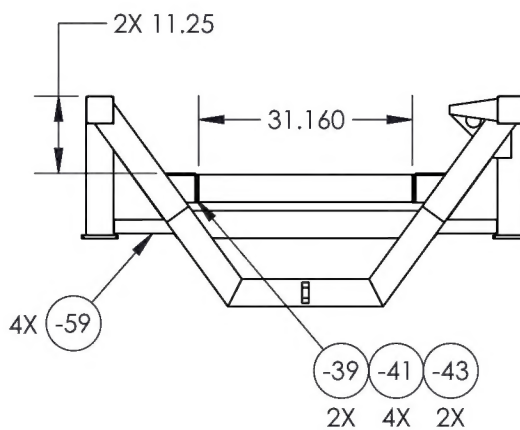
REVISIONS			DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION			
1		RELEASED FOR PRODUCTION.	4/27/2017	SM	JAG



SECTION R-R



SECTION M-M



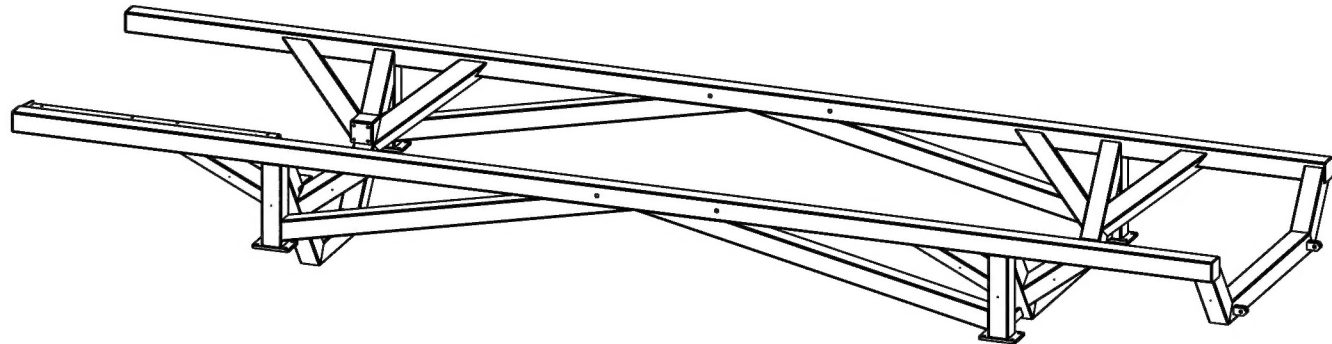
MAIN FRAME

NOTE:
FILLET WELD ALL JOINTS MINIMUM 90%.

DART AEROSPACE		
TITLE SUPPORT DOLLY, TAILBOOM		
DWG NO. RB T102012-1	REV 1	
MAT'L HEAT TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125/	
DRAWN BY: CHECKED: OPPS APPR: QA APPR:	GILBERT CLOUGH ANDERSON LINDSAY	
APPROVED:	GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:28	DATE 3/13/2014	SHEET 1 OF 29

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REV	ECR	DESCRIPTION	DATE
INITIAL	APPROVED		



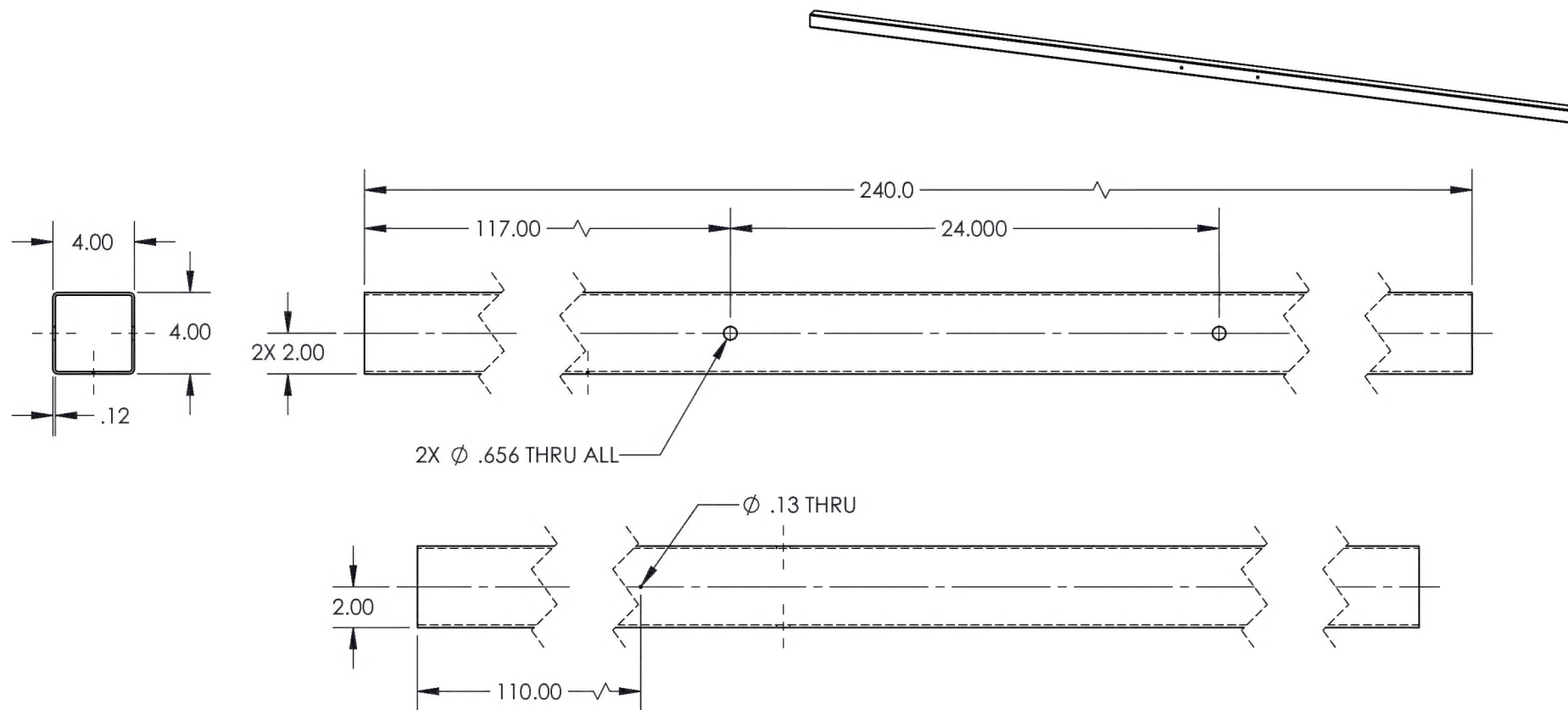
ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-21	2	TOP RAIL	STEEL TUBE		3
			-23	4	MAIN FRAME UPRIGHT	STEEL TUBE		4
			-25	4	MAIN FRAME OUTSIDE BRACE	STEEL TUBE		5
			-27	1	MAIN FRAME 1 BOTTOM	STEEL TUBE		6
			-29	2	MAIN FRAME 1 SIDE	STEEL TUBE		7
			-31	1	MAIN FRAME 2 BOTTOM	STEEL TUBE		8
			-33	2	MAIN FRAME 2 SIDE	STEEL TUBE		9
			-35	1	MAIN FRAME 3 BOTTOM	STEEL TUBE		10
			-37	2	MAIN FRAME 3 SIDE	STEEL TUBE		11
			-39	2	MAIN FRAME 1 PIVOT	STEEL TUBE		12
			-41	4	MAIN FRAME 1 PIVOT SIDE REINFORCEMENT	A36/1018/1020 HR		13
			-43	2	MAIN FRAME 1 PIVOT TOP REINFORCEMENT	A36/1018/1020 HR		14
			-45	1	MAIN FRAME INSIDE BRACE POWER PACK	STEEL TUBE		15
			-47	2	MAIN FRAME INSIDE BRACE MIRROR	A36/1018/1020 HR		16
			-49	1	MAIN FRAME INSIDE BRACE	STEEL TUBE		17
			-51	2	MAIN FRAME TB INSIDE BRACE	STEEL TUBE		18
			-53	2	MAIN FRAME TB INSIDE BRACE MIRROR	STEEL TUBE		19
			-55	4	MAIN FRAME WHEEL PLATE	A36/1018/1020 HR		20
			-57	4	MAIN FRAME END CAP	A36/1018/1020 HR		21
			-59	4	MAIN FRAME 2 UPRIGHT BRACE	A36/1018/1020 HR		22
			-61	1	MAIN FRAME POWER PACK BASE	A36/1018/1020 HR		23
			-63	1	MAIN FRAME POWER PACK GUSSET	A36/1018/1020 HR		24
			-65	1	MAIN FRAME POWER PACK GUSSET 2	A36/1018/1020 HR		25
			-67	4	MAIN FRAME TOWBAR MOUNT	A36/1018/1020 HR		26
			-69	1	MAIN FRAME 1 PISTON TAB	A36/1018/1020 HR		27
	X		-73	2	WELDED PIVOT PLATE ASSEMBLY			28
	1		-75		MAIN FRAME WELD PIVOT PLATE	A36/1018/1020 HR		29
	4	B/O	-77		HEX NUT	STEEL	3/8-24 (MCMASTER-CARR #90499A815)	28
	-73 ASSY							



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-1	
REV		1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .010 FRACTIONS ± 1/8	
SPEC		.XX ± .03 ANGLES ± 1°	
FED #13538		.X ± .1 SURFACES = 125°	
DRAWN BY:		GILBERT	
CHECKED:		CLOUGH	
OPPS APPR:		ANDERSON	
QA APPR:		LINDSAY	
APPROVED:		GILBERT	
SCALE		1:36	
DATE		3/13/2014	
SHEET		2 OF 29	

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			INITIAL
			APPROVED



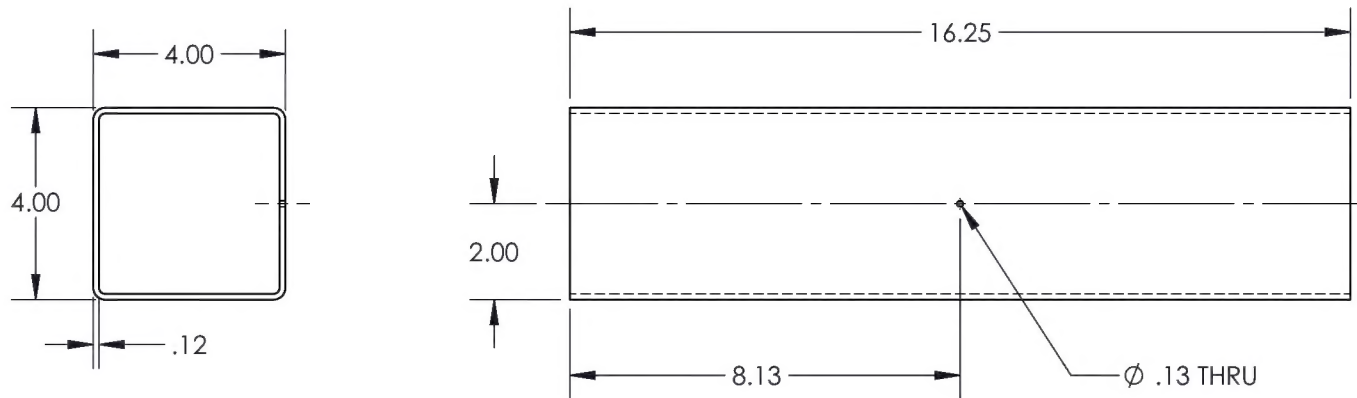
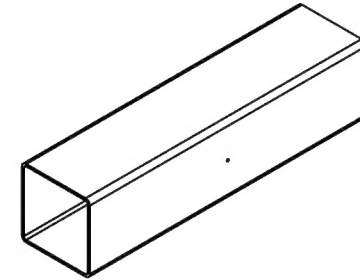
DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-21	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 3 OF 29

(21)

TOP RAIL

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				APPROVED

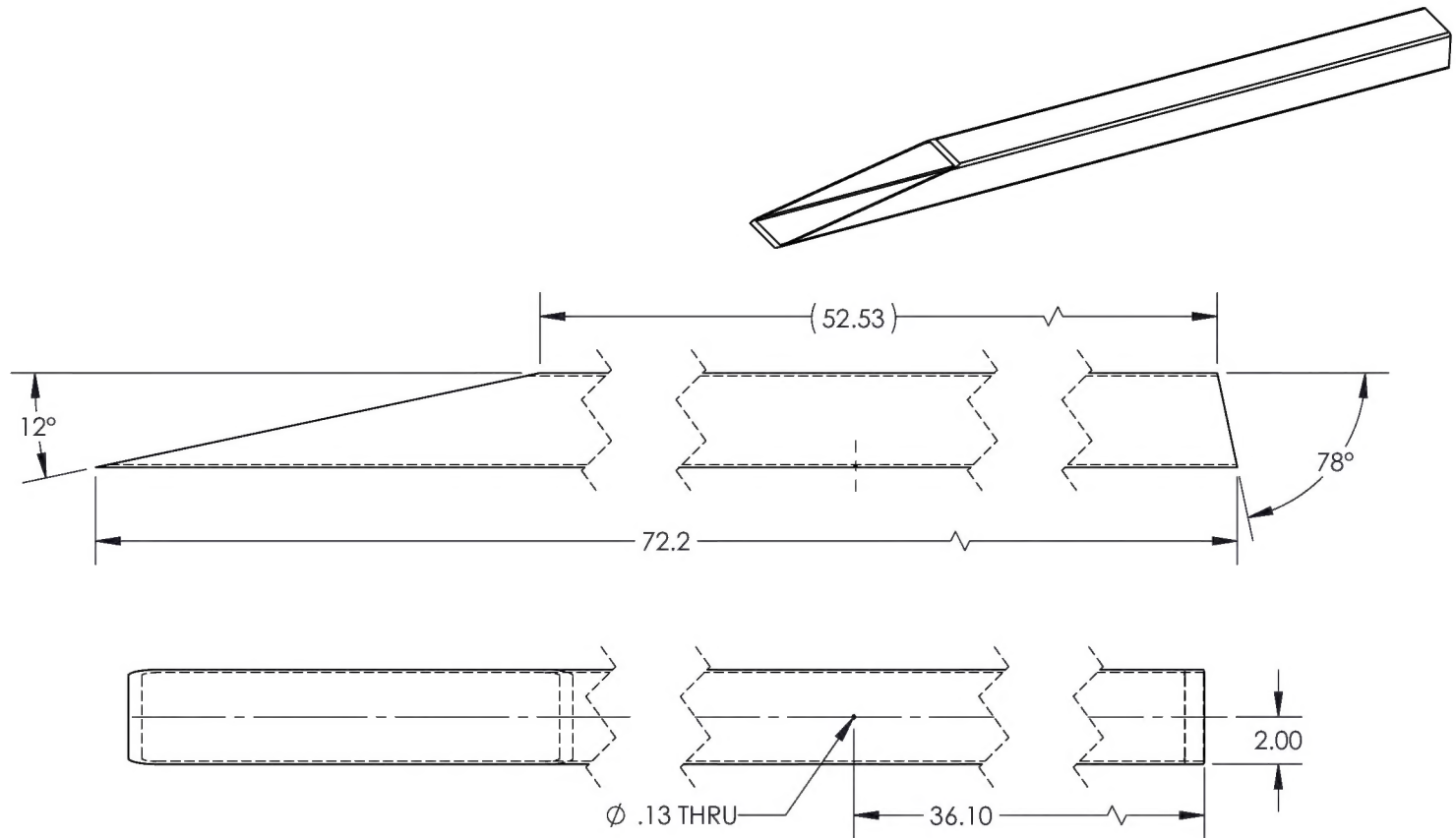
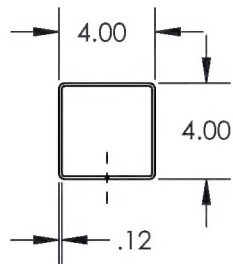


(-23)
MAIN FRAME UPRIGHT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-23	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:4	DATE 3/13/2014
	SHEET 4 OF 29

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				APPROVED



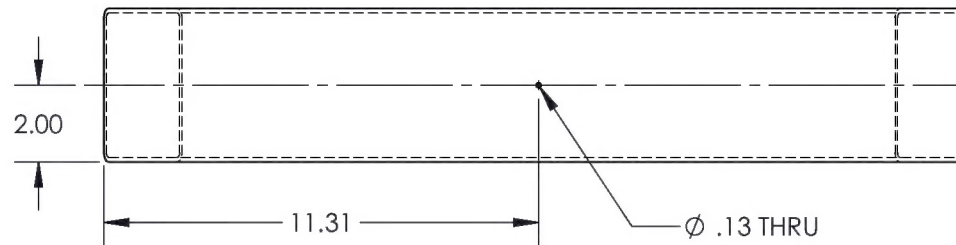
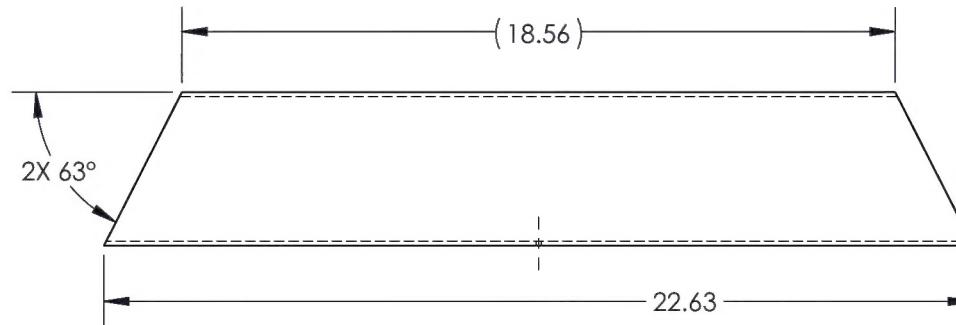
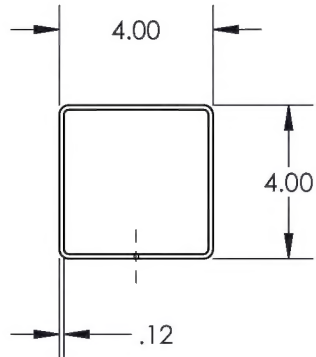
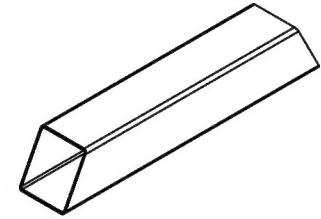
(25)

MAIN FRAME OUTSIDE BRACE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-25	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 5 OF 29

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				APPROVED



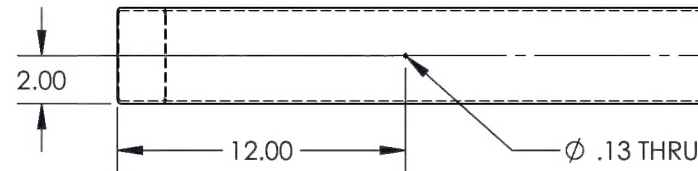
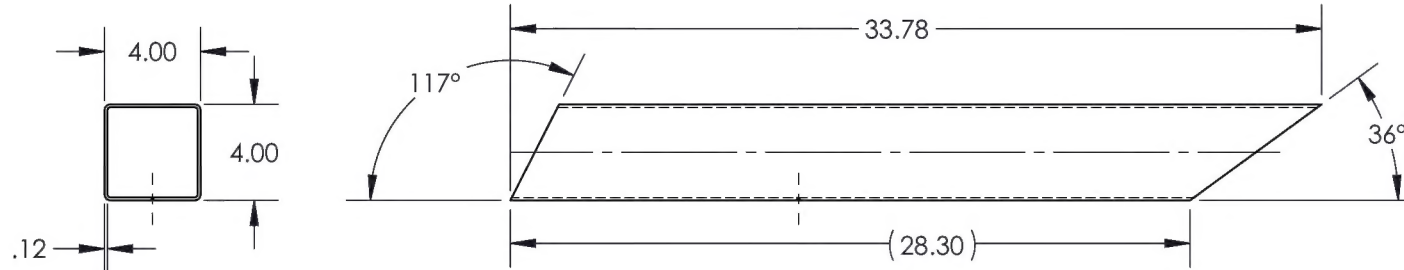
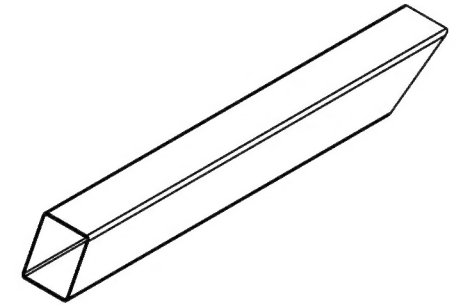
(-27)

MAIN FRAME 1 BOTTOM

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-27	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:5	DATE 3/13/2014
	SHEET 6 OF 29

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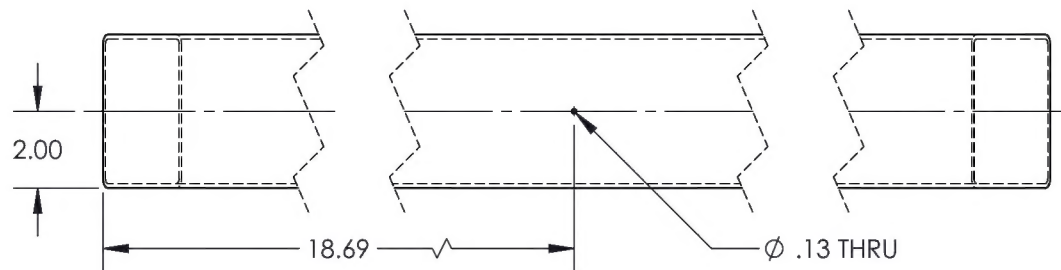
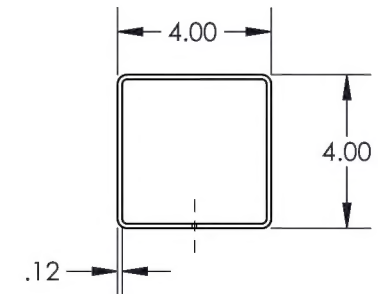
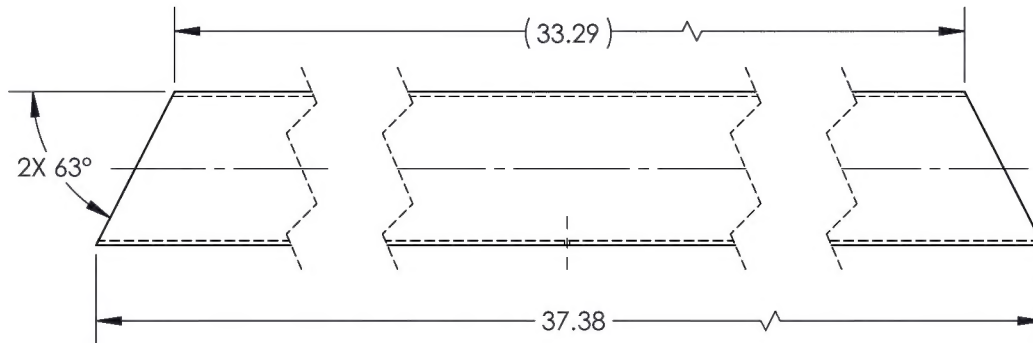
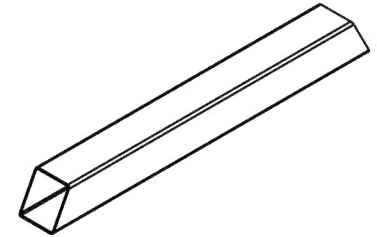
(29)

MAIN FRAME 1 SIDE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-29	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 7 OF 29

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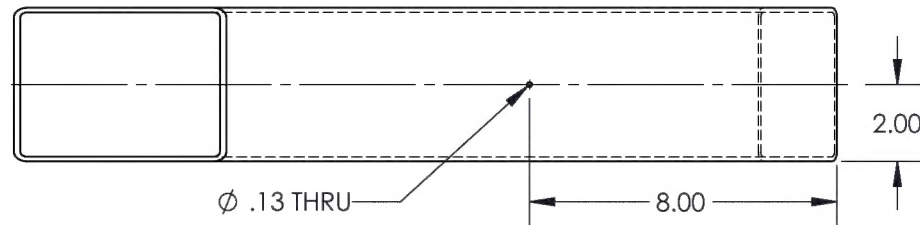
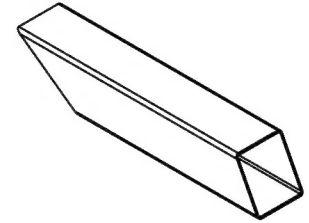
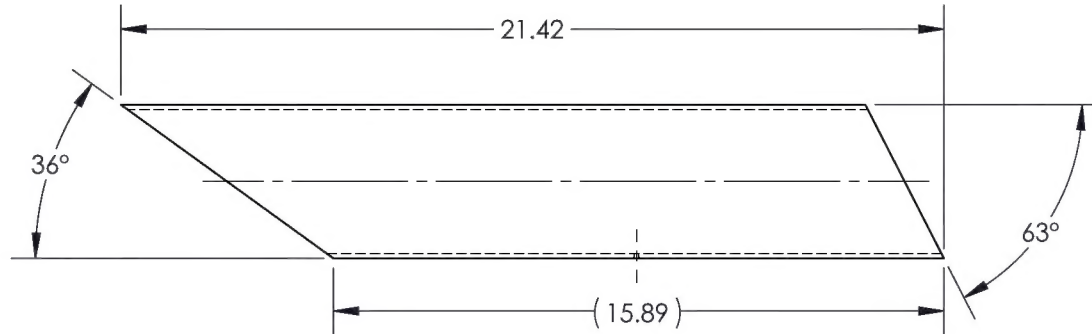
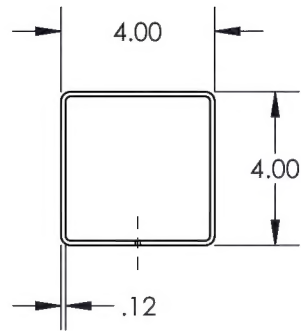
(-31)

MAIN FRAME 2 BOTTOM

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-31	REV 1
MAT'L STEEL TUBE TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE 1:5	DATE 3/13/2014
SHEET 8 OF 29	

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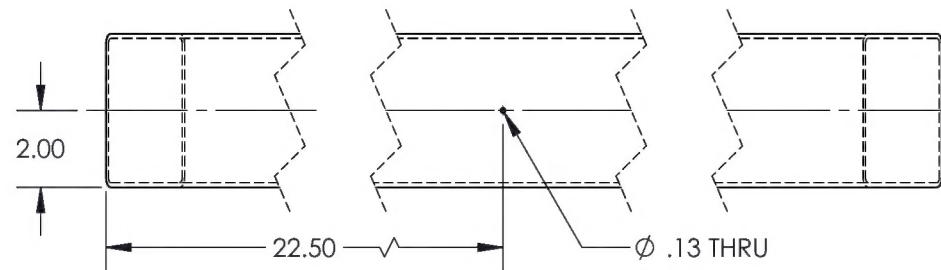
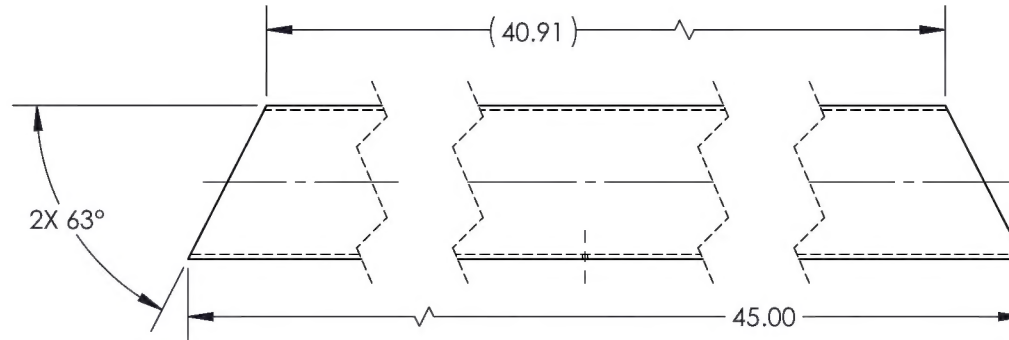
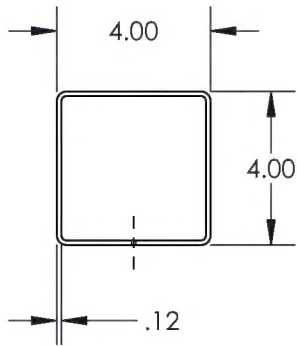
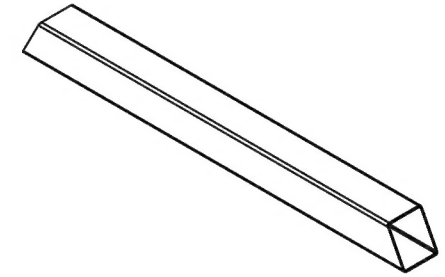
(-33)

MAIN FRAME 2 SIDE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-33	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:5	DATE 3/13/2014
	SHEET 9 OF 29

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REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED



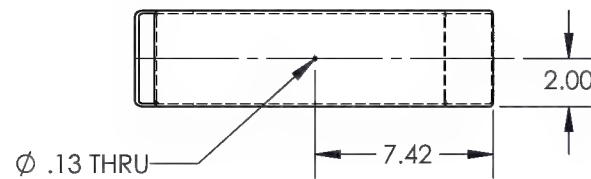
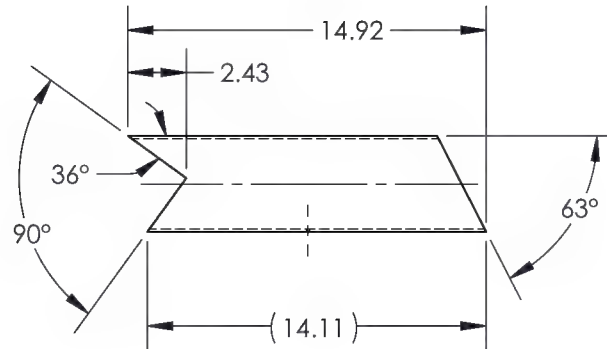
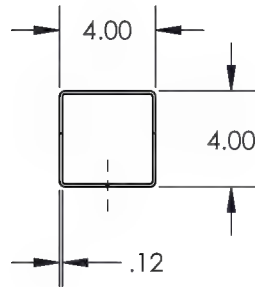
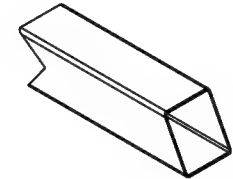
(35)

MAIN FRAME 3 BOTTOM

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-35	REV 1
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
SCALE	1:5
DATE	3/13/2014
SHEET 10 OF 29	

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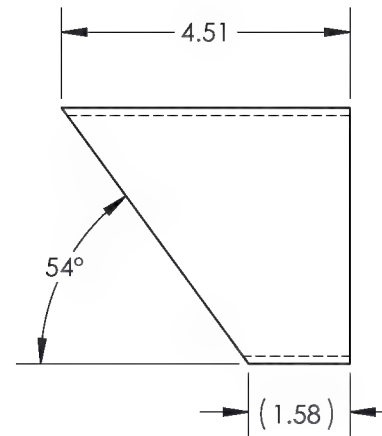
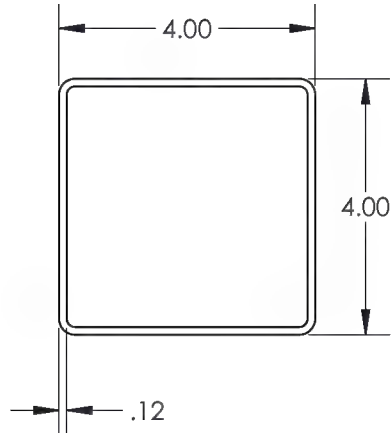
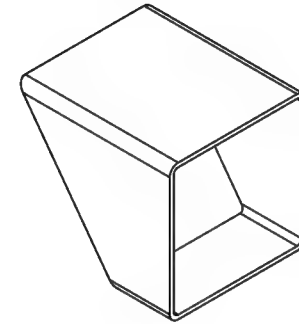
(-37)

MAIN FRAME 3 SIDE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-37	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 11 OF 29

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				APPROVED



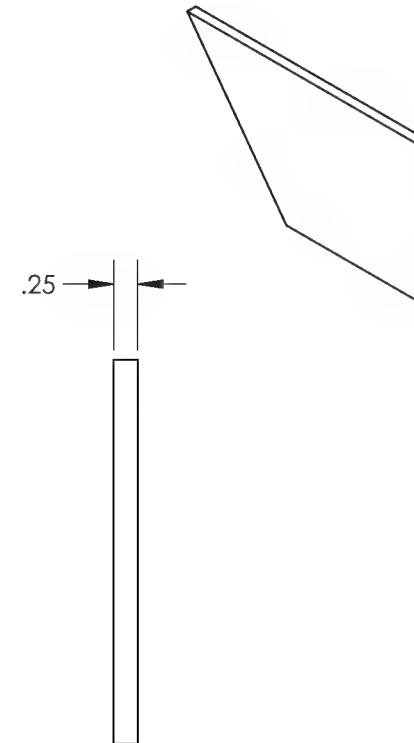
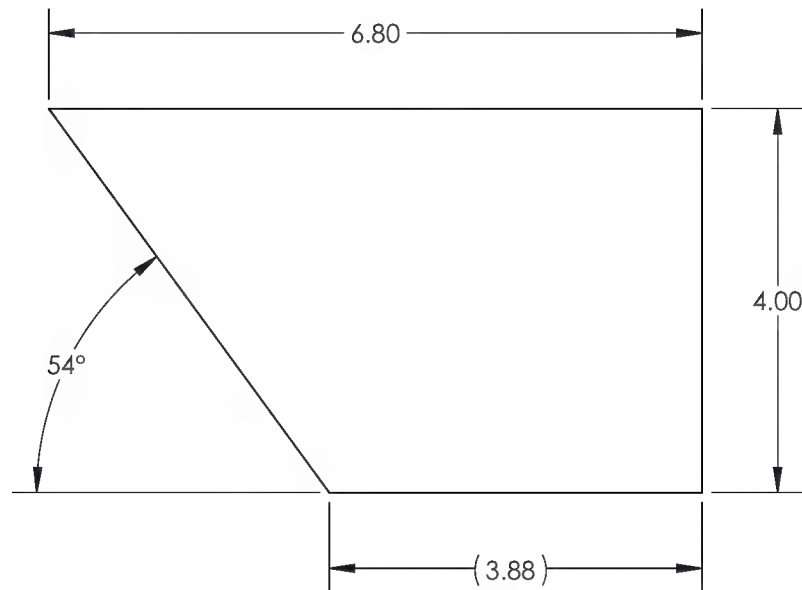
(-39)

MAIN FRAME 1 PIVOT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-39	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125/✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:3	DATE 3/13/2014
	SHEET 12 OF 29

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



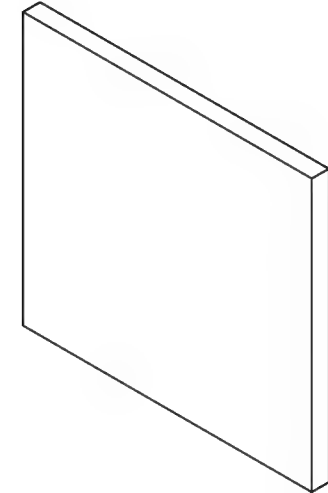
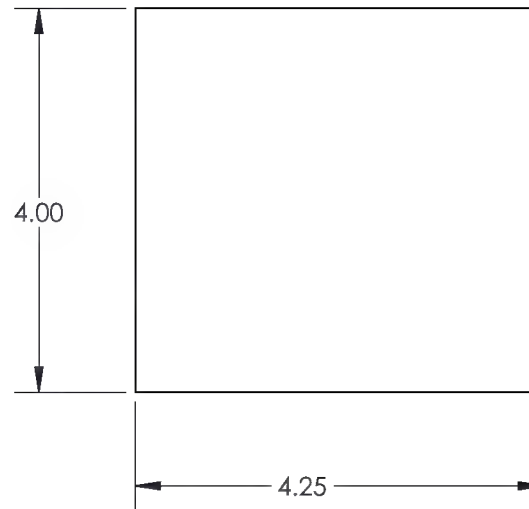
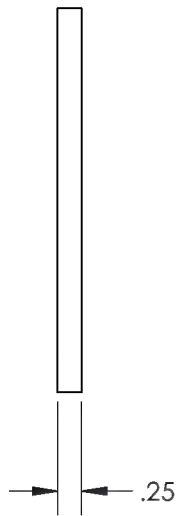
(-41)

MAIN FRAME 1 PIVOT SIDE REINFORCEMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-41	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 13 OF 29

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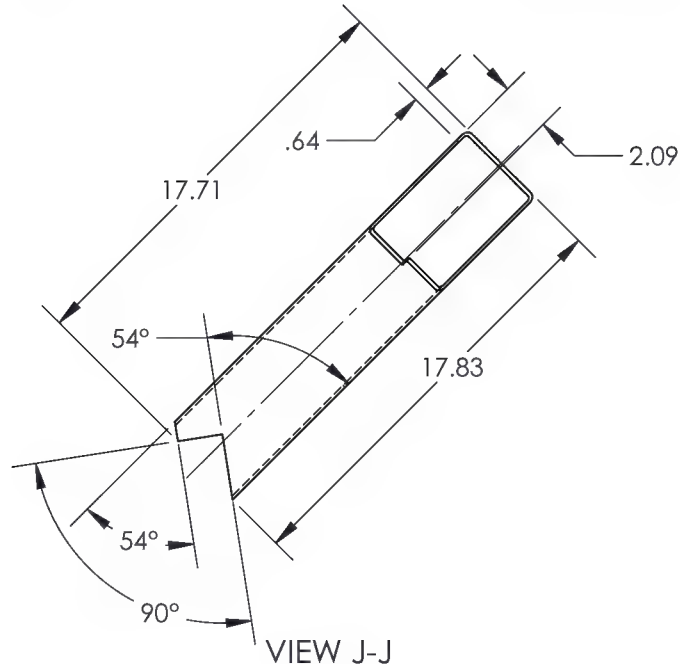
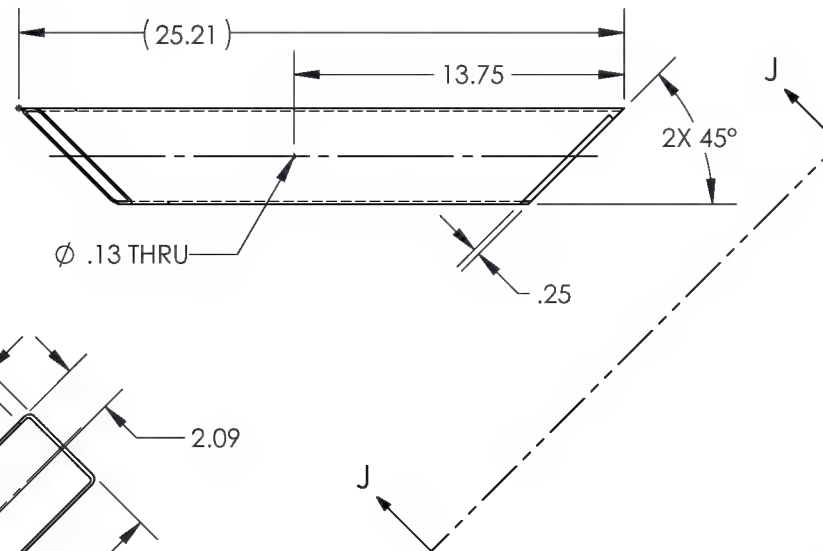
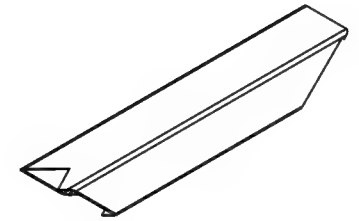
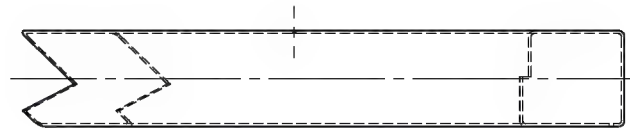
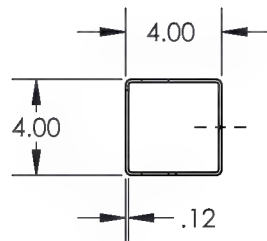
(-43)

MAIN FRAME 1 PIVOT TOP REINFORCEMENT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-43	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 14 OF 29

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VIEW J-J

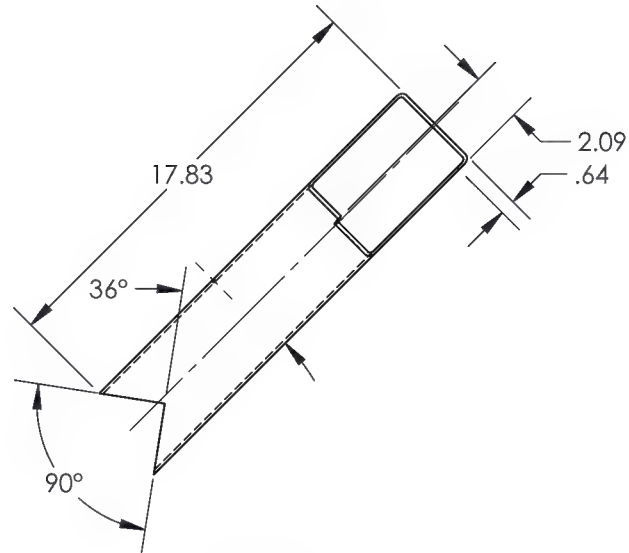
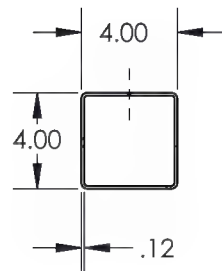
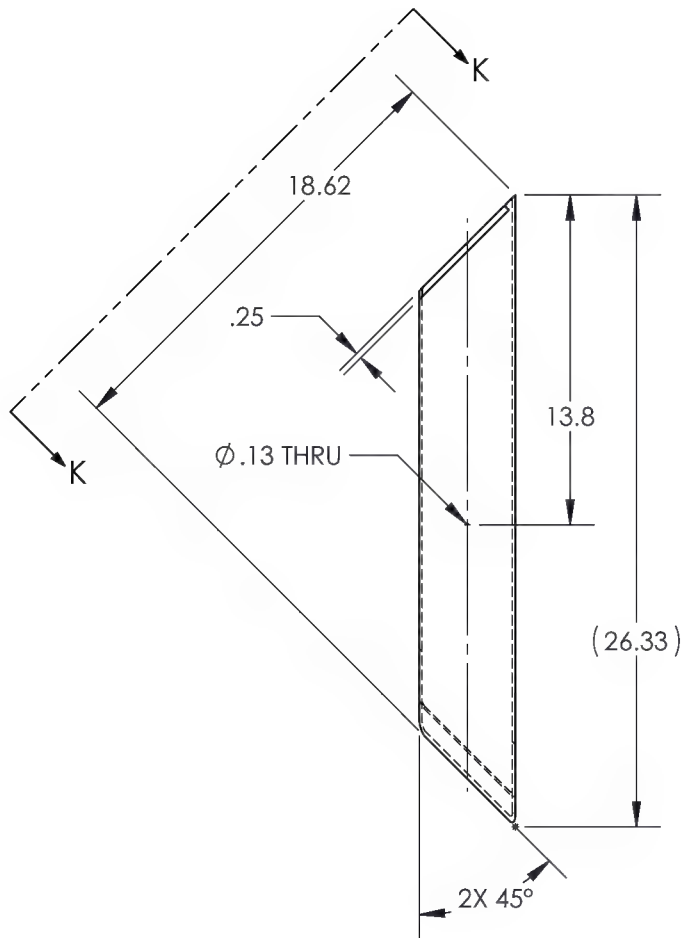
(-45)

MAIN FRAME INSIDE BRACE POWER PACK

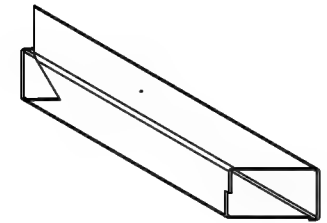
DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-45	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	BELL 212, 214B, 214ST, 412
SCALE 1:8	DATE 3/13/2014
	SHEET 15 OF 29

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VIEW K-K



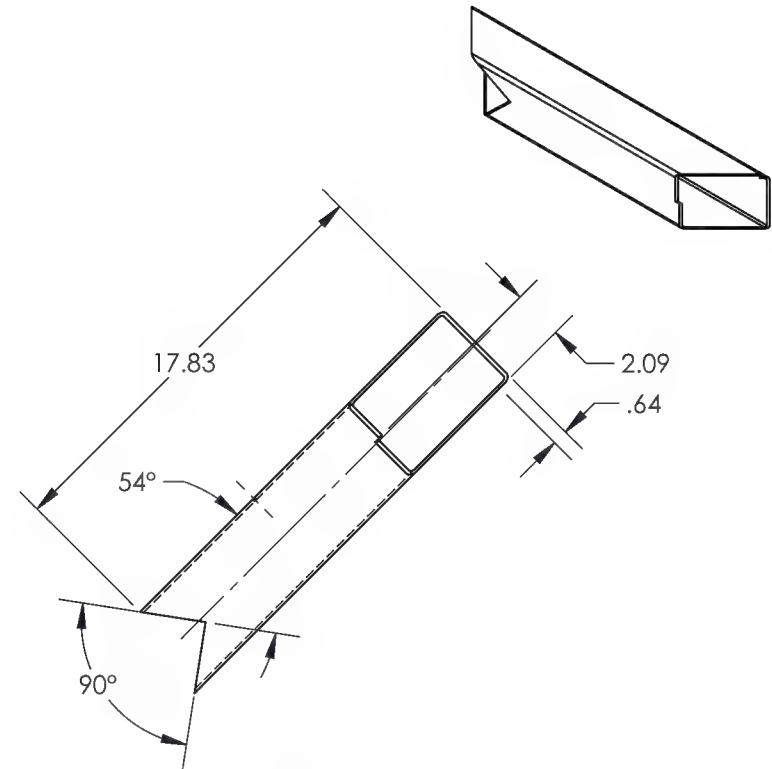
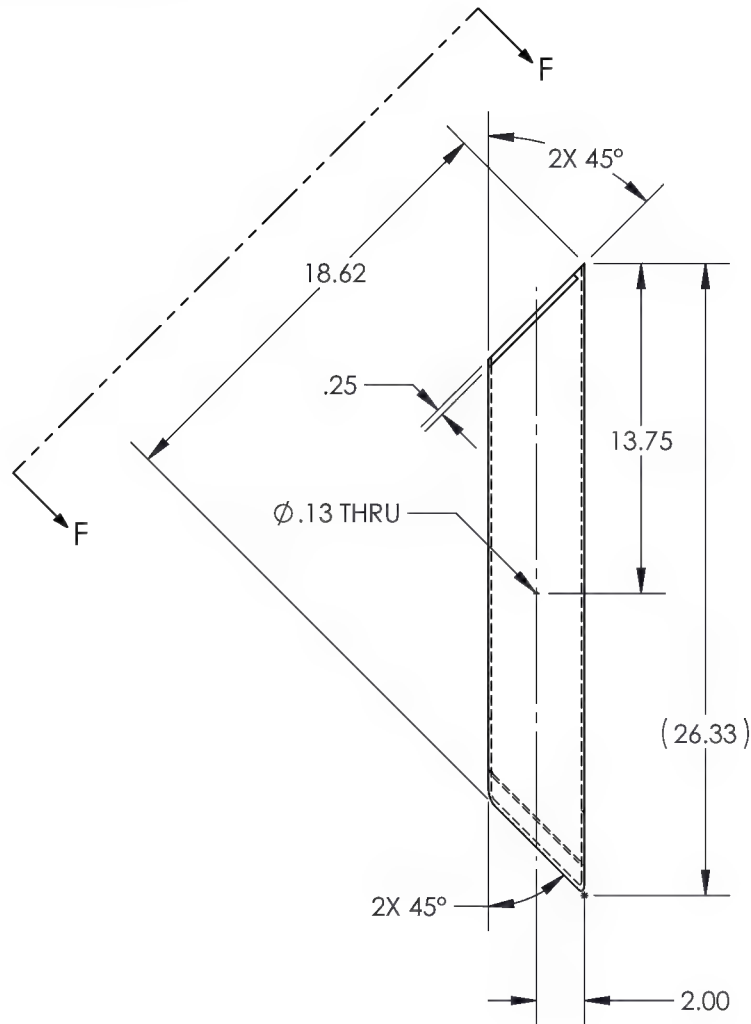
DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-47	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 16 OF 29

MAIN FRAME INSIDE BRACE MIRROR

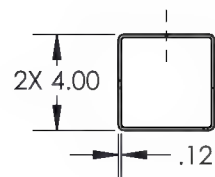
(-47)

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VIEW F-F



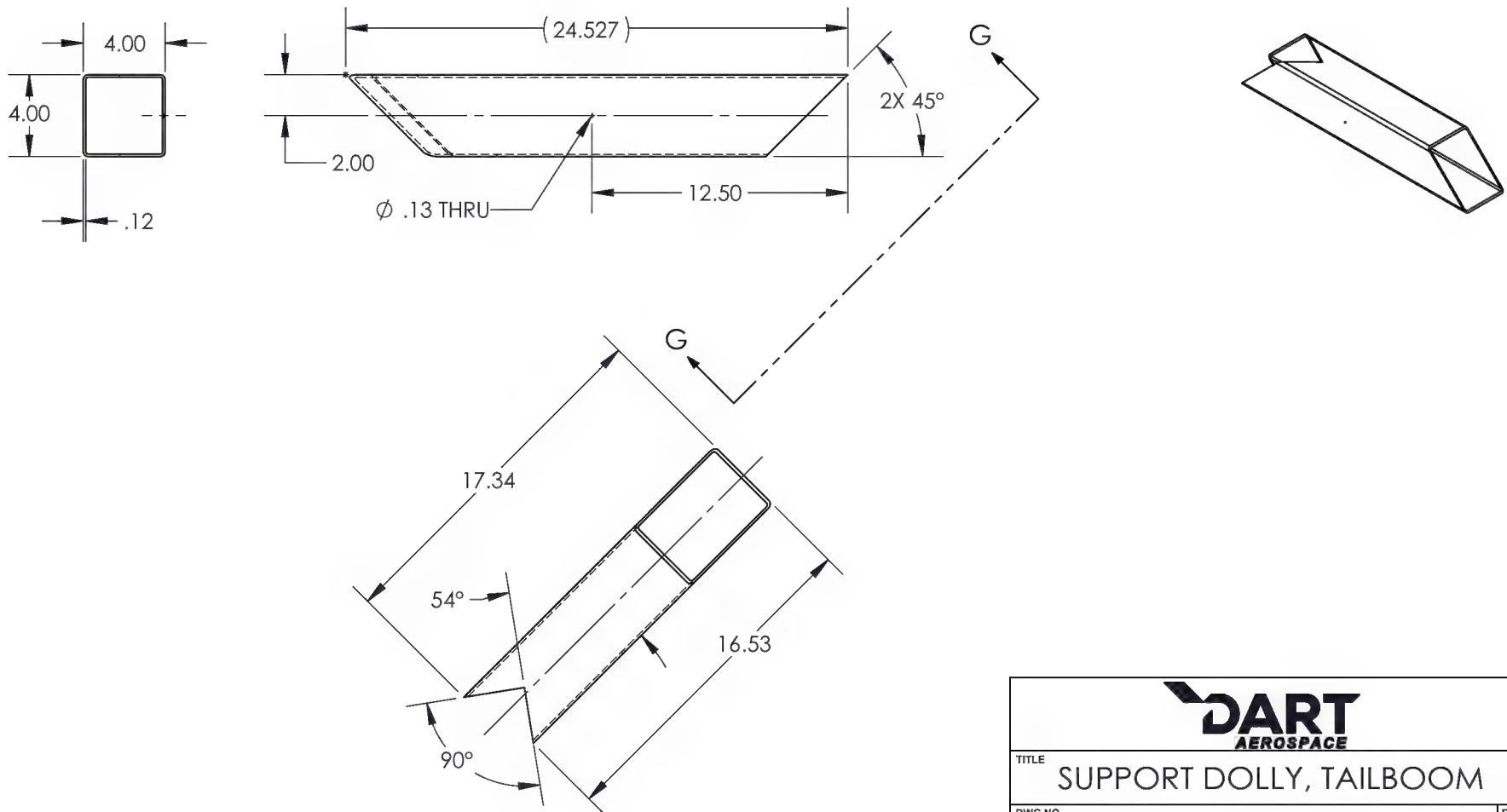
(-49)

MAIN FRAME INSIDE BRACE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-49	REV 1
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	GILBERT
CHECKED:	CLOUGH
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	GILBERT
USED ON MODEL	
BELL 212, 214B, 214ST, 412	
SCALE 1:8	DATE 3/13/2014
SHEET 17 OF 29	

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			APPROVED



VIEW G-G

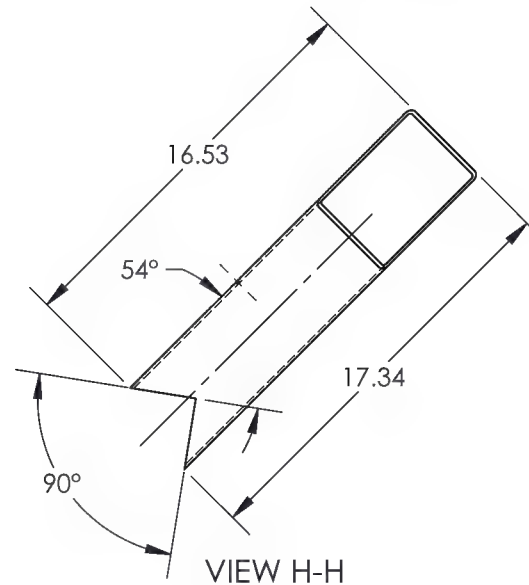
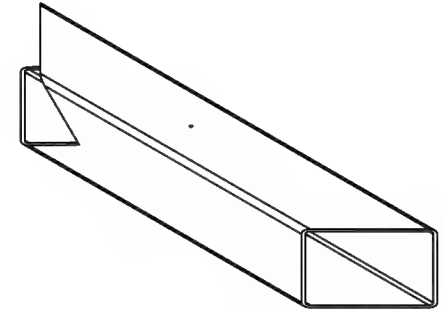
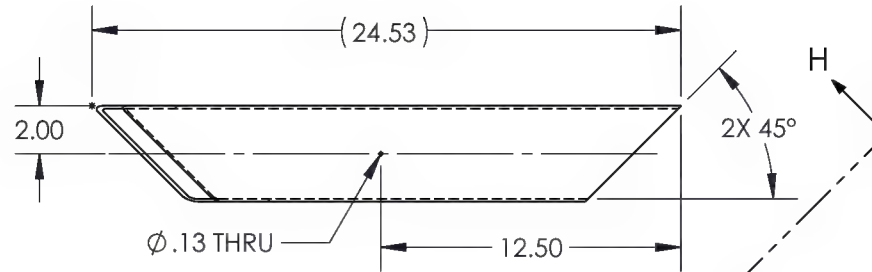
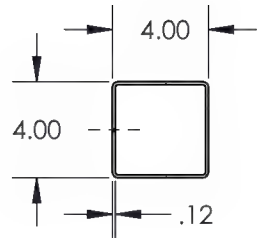
(-51)

MAIN FRAME TB INSIDE BRACE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-51	REV 1
MAT'L STEEL TUBE HEAT TREAT FINISH SEE -1 WELDMENT SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: CLOUGH	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:8	DATE 3/13/2014
SHEET 18 OF 29	

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VIEW H-H

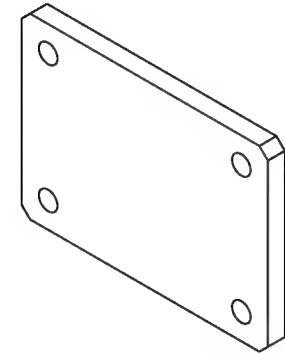
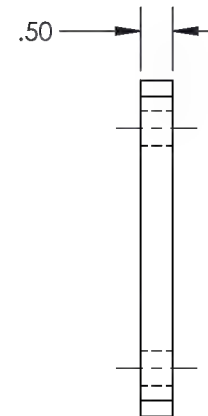
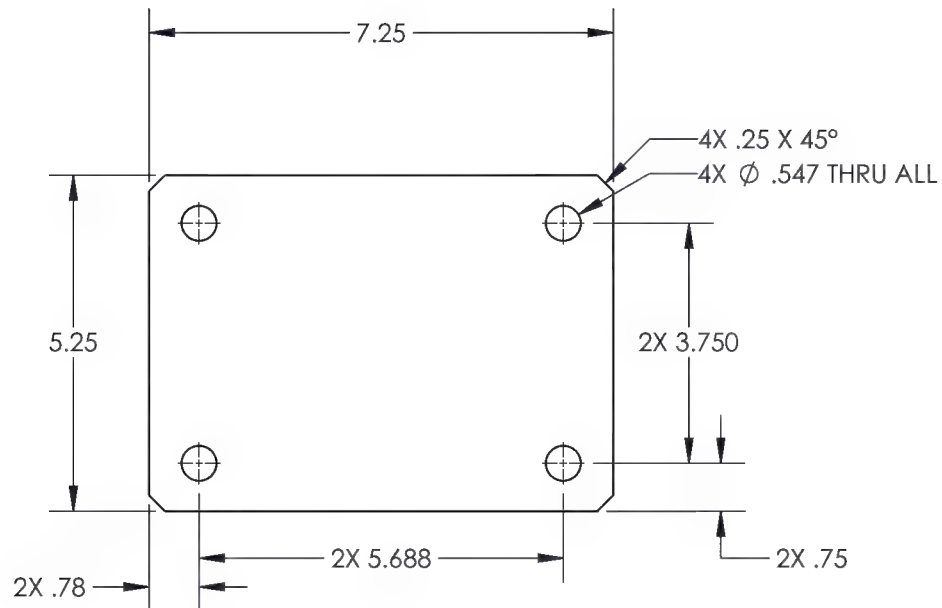
(-53)

MAIN FRAME TB INSIDE BRACE MIRROR

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-53	REV 1
MAT'L STEEL TUBE	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:8	DATE 3/13/2014
	SHEET 19 OF 29

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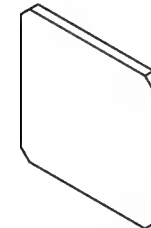
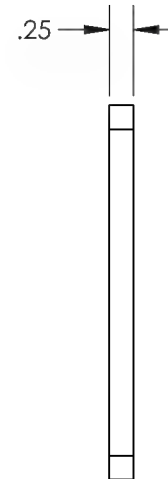
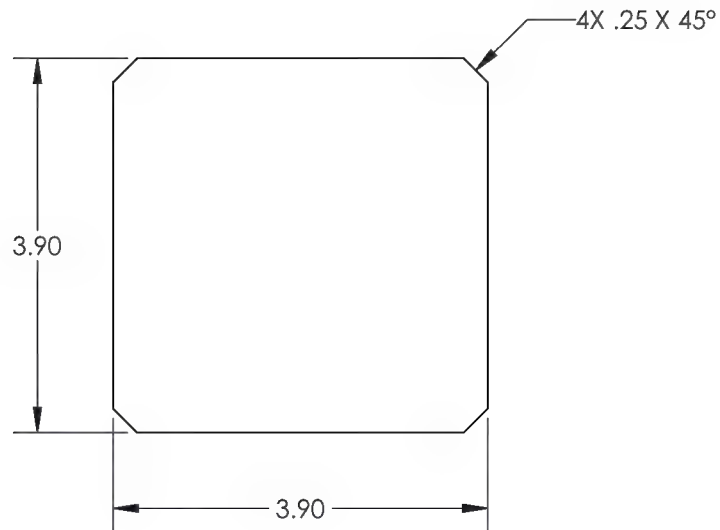
(-55)

MAIN FRAME WHEEL PLATE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-55	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	BELL 212, 214B, 214ST, 412
SCALE 1:3	DATE 3/13/2014
	SHEET 20 OF 29

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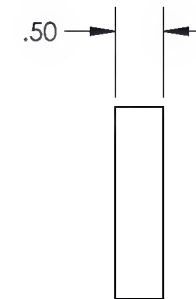
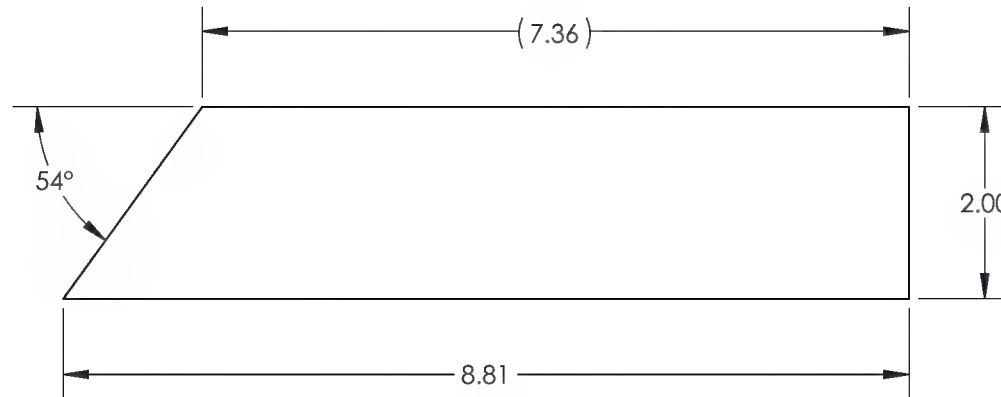
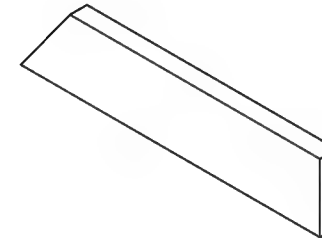


(-57)
MAIN FRAME END CAP

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-57	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 21 OF 29

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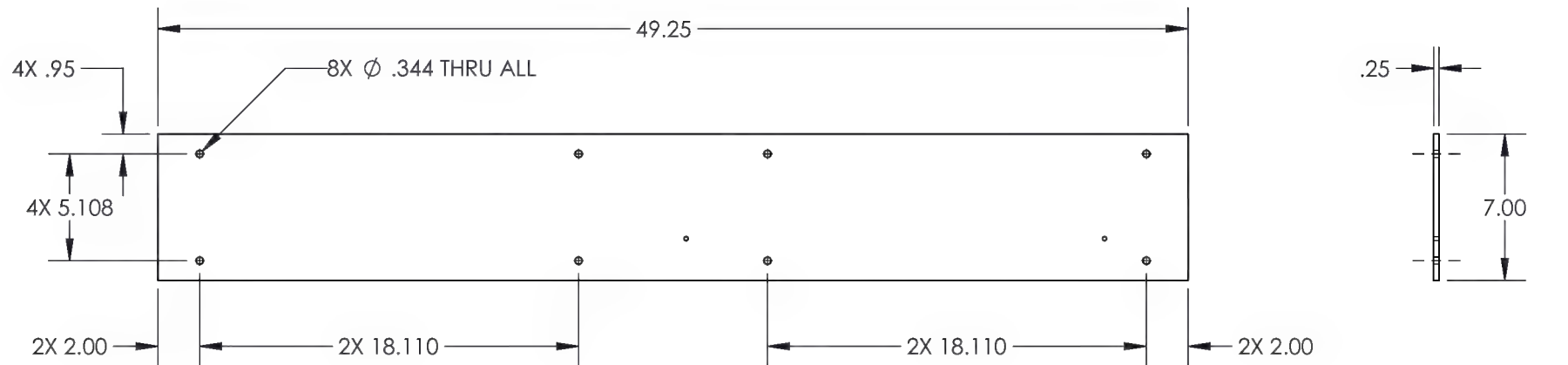
-59

MAIN FRAME 2 UPRIGHT BRACE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-59	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	BELL 212, 214B, 214ST, 412
SCALE 1:2	DATE 3/13/2014
	SHEET 22 OF 29

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REV	ECR	DESCRIPTION	DATE



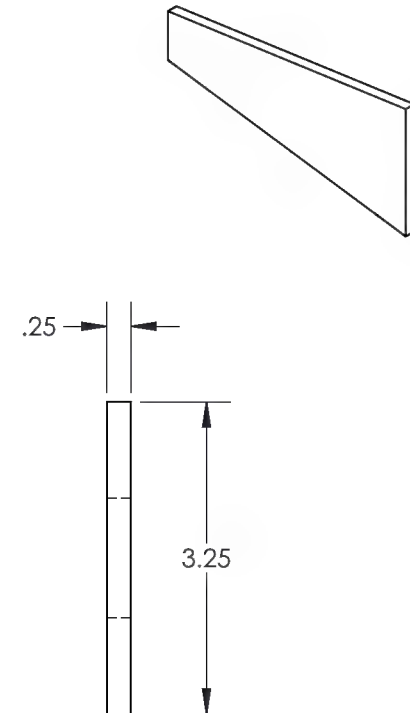
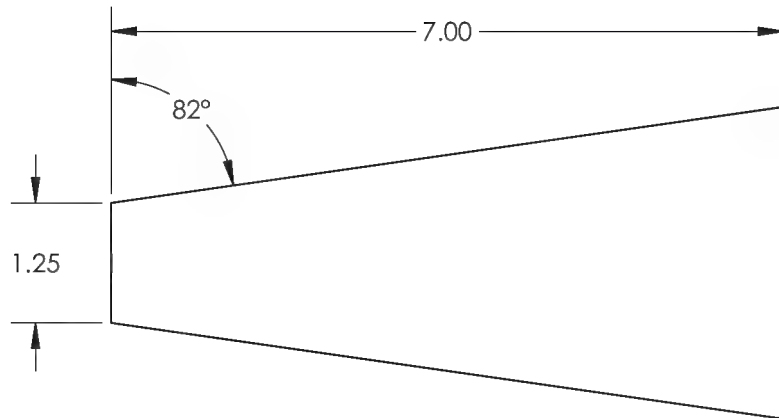
(-61)

MAIN FRAME POWER PACK BASE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-61	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
FINISH SEE -1 WELDMENT	.XX ± .03 ANGLES ± 1°
SPEC	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:8	DATE 3/13/2014
SHEET 23 OF 29	

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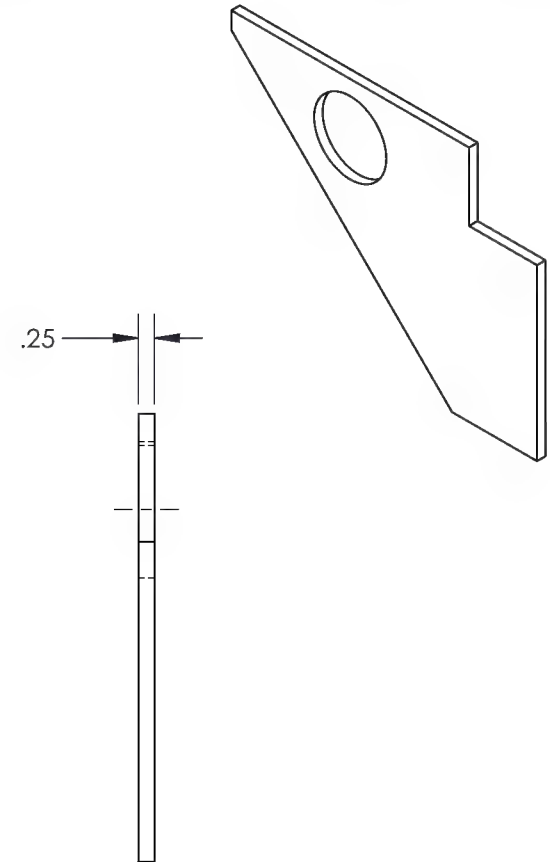
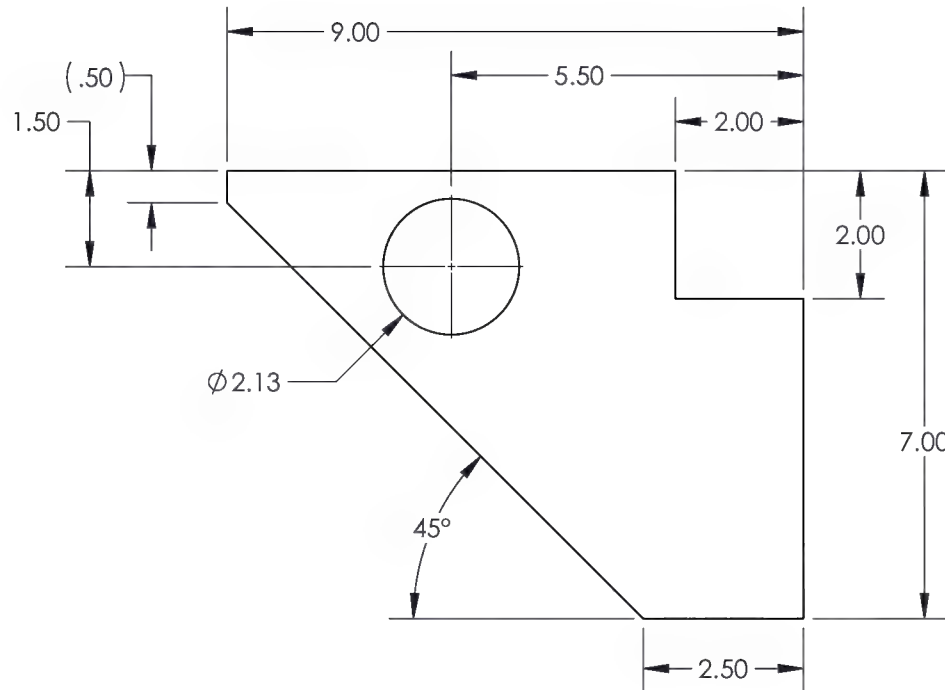
(-63)

MAIN FRAME POWER PACK GUSSET

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-63	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 24 OF 29

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			INITIAL
			APPROVED



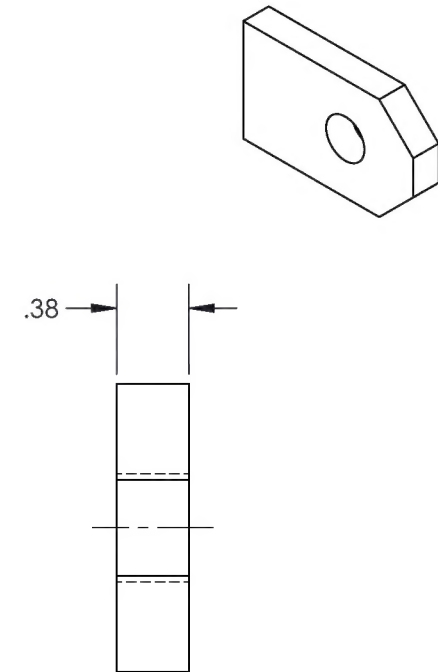
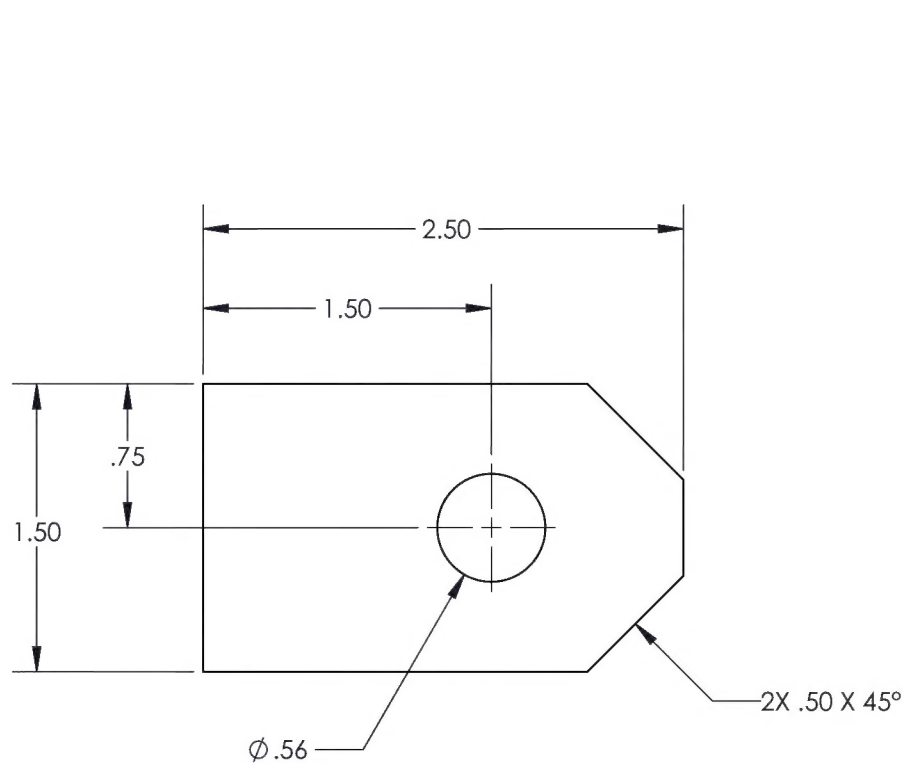
(-65)

MAIN FRAME POWER PACK GUSSET 2

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-65	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT SEE -1 WELDMENT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	BELL 212, 214B, 214ST, 412
SCALE 1:3	DATE 3/13/2014
SHEET 25 OF 29	

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				APPROVED



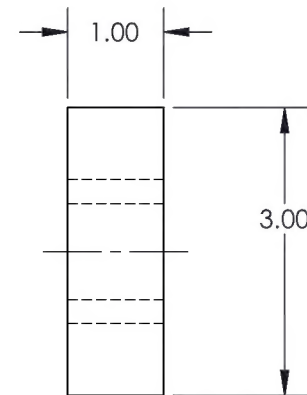
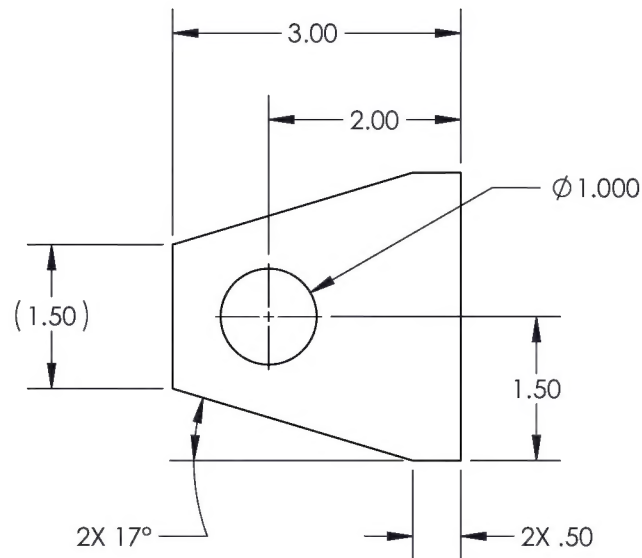
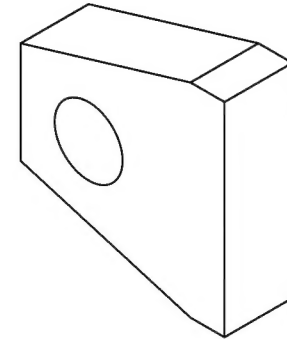
(-67)

MAIN FRAME TOWBAR MOUNT

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-67	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 3/13/2014
	SHEET 26 OF 29

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



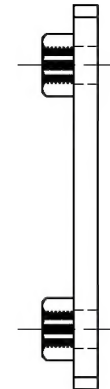
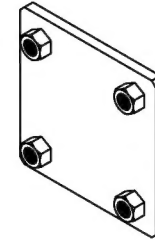
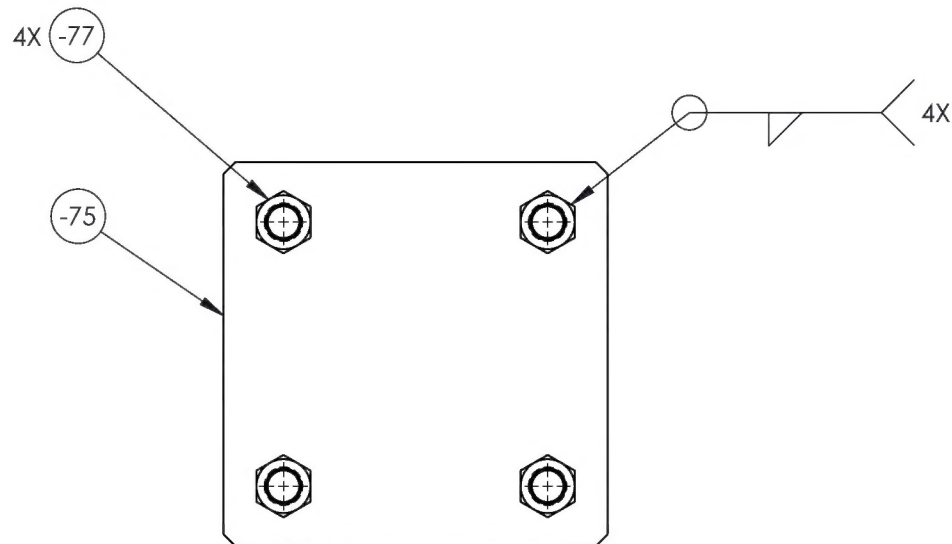
-69

MAIN FRAME 1 PISTON TAB

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-69	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 27 OF 29

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				APPROVED



(-73)

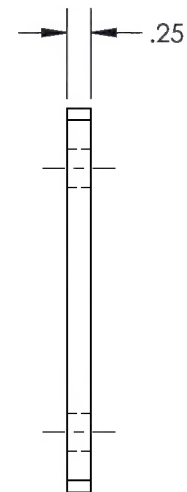
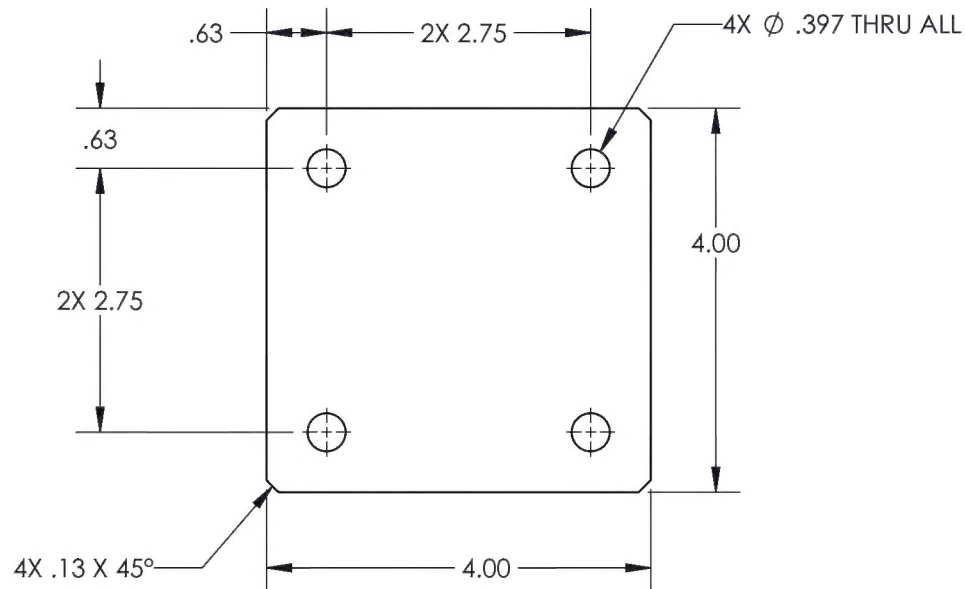
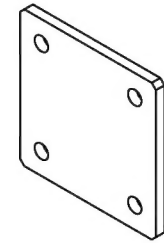
WELDED PIVOT PLATE ASSEMBLY



TITLE		SUPPORT DOLLY, TAILBOOM	
DWG NO.		RB T102012-73	
		REV 1	
MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .010 FRACTIONS ± 1/8	
FINISH SEE -1 WELDMENT		.XX ± .03 ANGLES ± 1°	
		.X ± .1 SURFACES = 125°	
SPEC		1. BREAK ALL SHARP EDGES	
DRAWN BY: GILBERT		.015 x 45° OR .015R	
CHECKED: CLOUGH		2. DIMENSIONAL LIMITS APPLY	
OPPS APPR: ANDERSON		AFTER PLATING	
QA APPR: LINDSAY		3. INTERPRET DIM AND TOL PER	
APPROVED: GILBERT		ASME Y14.5M-2009	
SCALE 1:2		DATE 3/13/2014	
		SHEET 28 OF 29	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-75)

MAIN FRAME WELD PIVOT PLATE

DART AEROSPACE	
TITLE SUPPORT DOLLY, TAILBOOM	
DWG NO. RB T102012-75	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1 WELDMENT	.XXX ± .010 FRACTIONS ± 1/8
SPEC	.XX ± .03 ANGLES ± 1°
	.X ± .1 SURFACES = 125°
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:2	DATE 3/13/2014
	SHEET 29 OF 29